

**Work Order ID 50196**

July 10, 2009 11:23:21 AM



Page 1

Item ID: D2989-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Basket Lid Assembly

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

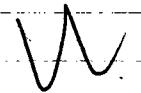
Required Date: 7/27/09 Req'd Qty: 1.00



Customer:

**Reference:**

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr							
----------	--------------	--	--	--	--	--	--	--

D2989	Rev D							
-------	-------	--	--	--	--	--	--	--

100 0.00

Large Fab	Memo	0.00						
-----------	------	------	--	--	--	--	--	--

Large Fab	Memo	0.00						
-----------	------	------	--	--	--	--	--	--

Large Fab	Memo	0.00						
-----------	------	------	--	--	--	--	--	--

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989-2-tack weld mesh on basket as per dwg D2989 using DT9445 jig\*\*\*\*cut cutouts with zip cut as per dwg D3832\*\*\*\*3- remove from jig and weld lable plate as per dwg D2989 A/R ER3

D 09.07.20

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00						
-----	--	------	--	--	--	--	--	--

QC	Memo	0.00						
----	------	------	--	--	--	--	--	--

Quality Control								
-----------------	--	--	--	--	--	--	--	--

120	QC5- Inspect part completeness to step on W/O	0.00						
-----	---	------	--	--	--	--	--	--

QC	Memo	0.00						
----	------	------	--	--	--	--	--	--

Quality Control								
-----------------	--	--	--	--	--	--	--	--

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(S) q

# Work Order ID 50196



Page 2

July 10, 2009 11:23:21 AM

Item ID: D2989-041

Accept



Setup Start



Revision ID: D

Item Name: Basket Lid Assembly

Stop



Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/27/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

130



Powdercoat

Powder Coating

Operation  
Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

*PRESS WASH*

Set Up/  
Run Hours

0.00

Draw  
Number

MU2148

Draw  
Rev.

BP

Plan  
Code

0000

Accept  
Qty

0

Reject  
Qty

0

Reject  
Number

0

Insp.  
Stamp

*EL 9-7-22*

140



QC

Quality Control

Memo

*PRESSWASH*

09-07-22 EL

0.00

QC3- Inspect Part Finish

*→ Solarisby*

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*09-07-22*

*mf 09-07-27*

W/O: 50196

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/7/23	# B00	ADD step to wing walk per Dwg. *	bf	09/07/23	①.		S 07/07/23
			bf	09/07/23			

Part No: D2989-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

# Picklist Print

Page 1

July 10, 2009 11:23:21 AM

Work Order ID: 50196



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 7/15/09

Required Date: 7/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2506RevF 		Manufactured	No			100	Each	5.0000	1.0000			

Label Plate

## Warehouse

### Location

Main Warehouse

ST

Loc Qty

5

44275

Loc Code

48607

AD 09.07.20

D2512-7RevE



Manufactured

No

100

Each

9.0000

Rib

## Warehouse

### Location

Main Warehouse

ST

Loc Qty

9

43987

PD 09.07.17

44865

48326

48666

1

1

3

4

D2581RevA1



Manufactured

No

100

Each

33.0000

Mounting Bracket

## Warehouse

### Location

Main Warehouse

ST

Loc Qty

33

46086

48428

2

31

PD 09.07.20

# Picklist Print

Page 2

July 10, 2009 11:23:21 AM

Work Order ID: 50196



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 7/15/09

Required Date: 7/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2989-13RevD		Manufactured	No			100	Each	6.0000	2.0000			

Rib

## Warehouse

### Location

#### Main Warehouse

ST	6
48327	2
48452	4

2 PD 09.07.17

A2221-1  
D2989-17RevD

09/07/17

Manufactured No

100 Each 0.0000 2.0000

48318 → 1  
48427 → 2

3 PD 09.07.20

Rib

D2989-19RevD

Manufactured No

100 Each 7.0000 2.0000

Rib

## Warehouse

### Location

#### Main Warehouse

ST	7
44867	1
47976	2
48102	4

2 PD 09.07.17

# Picklist Print

Page 3

July 10, 2009 11:23:21 AM

Work Order ID: 50196



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 7/15/09

Required Date: 7/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3832-3RevA		Manufactured	No			100	Each	6.0000	1.0000			

Mesh (Lid)

## Warehouse

### Location

Main Warehouse

ST 6

47747 3

48608 3

1 PD 09-07-20

D3833-3RevA

Manufactured No

100 Each 13.0000 2.0000

Mesh (Lid End)

## Warehouse

### Location

Main Warehouse

ST 13

46308 13

2 PD 09-07-20

D3836-041RevA

Manufactured No

100 Each 3.0000 1.0000

Rib Assembly (Basket Lid, LH)

## Warehouse

### Location

Main Warehouse

ST 3

48099 1

48440 2

1 PD 09-07-17

# Picklist Print

Page 4

July 10, 2009 11:23:21 AM

Work Order ID: 50196



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 7/15/09

Required Date: 7/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3836-042RevA		Manufactured	No			100	Each	3.0000	1.0000			

Rib Assembly (Basket Lid, RH)

## Warehouse

### Location

#### Main Warehouse

ST 3

46089 1

48441 2

1 PD 09.07.17

D3852-041RevA

Manufactured

No

100

Each

3.0000 1.0000

Rib Assembly

## Warehouse

### Location

#### Main Warehouse

ST 3

48098 3

1 PD 09.07.17

D3852-042RevA

Manufactured

No

100

Each

3.0000 1.0000

Rib Assembly

## Warehouse

### Location

#### Main Warehouse

ST 3

48097 3

1 PD 09.07.17

8

7

6

5

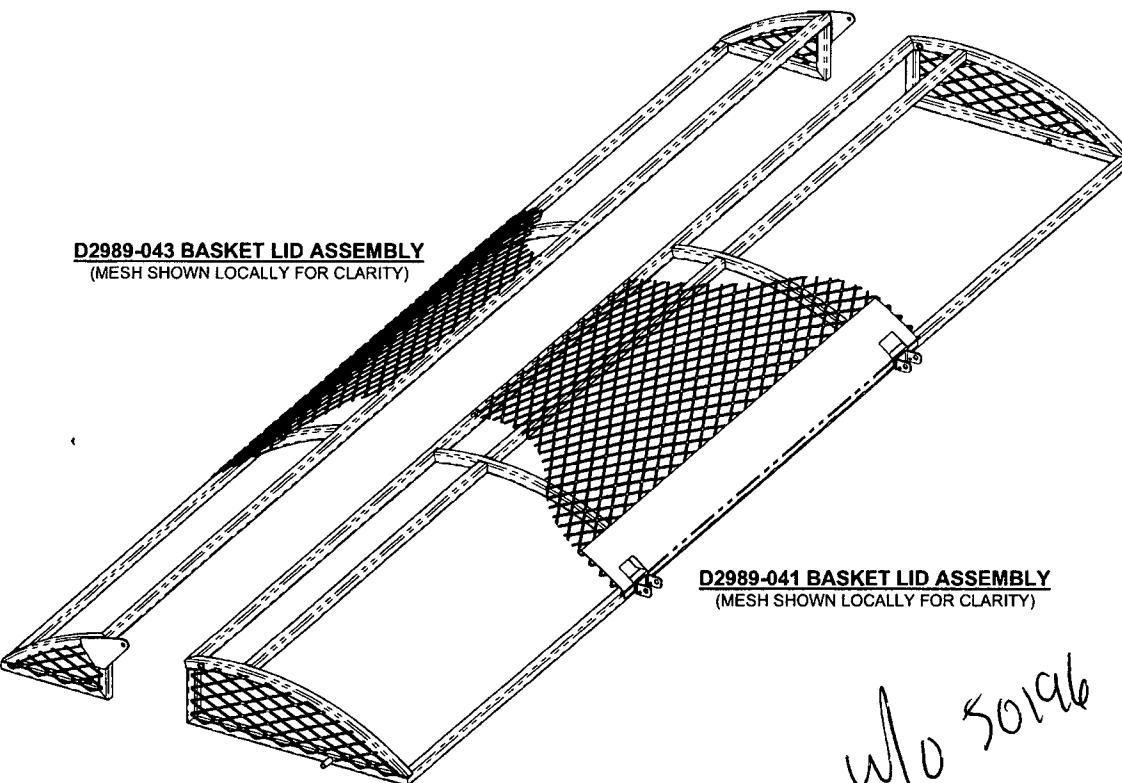
4

3

2

1

D



## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

8

7

6

5

4

3

2

1

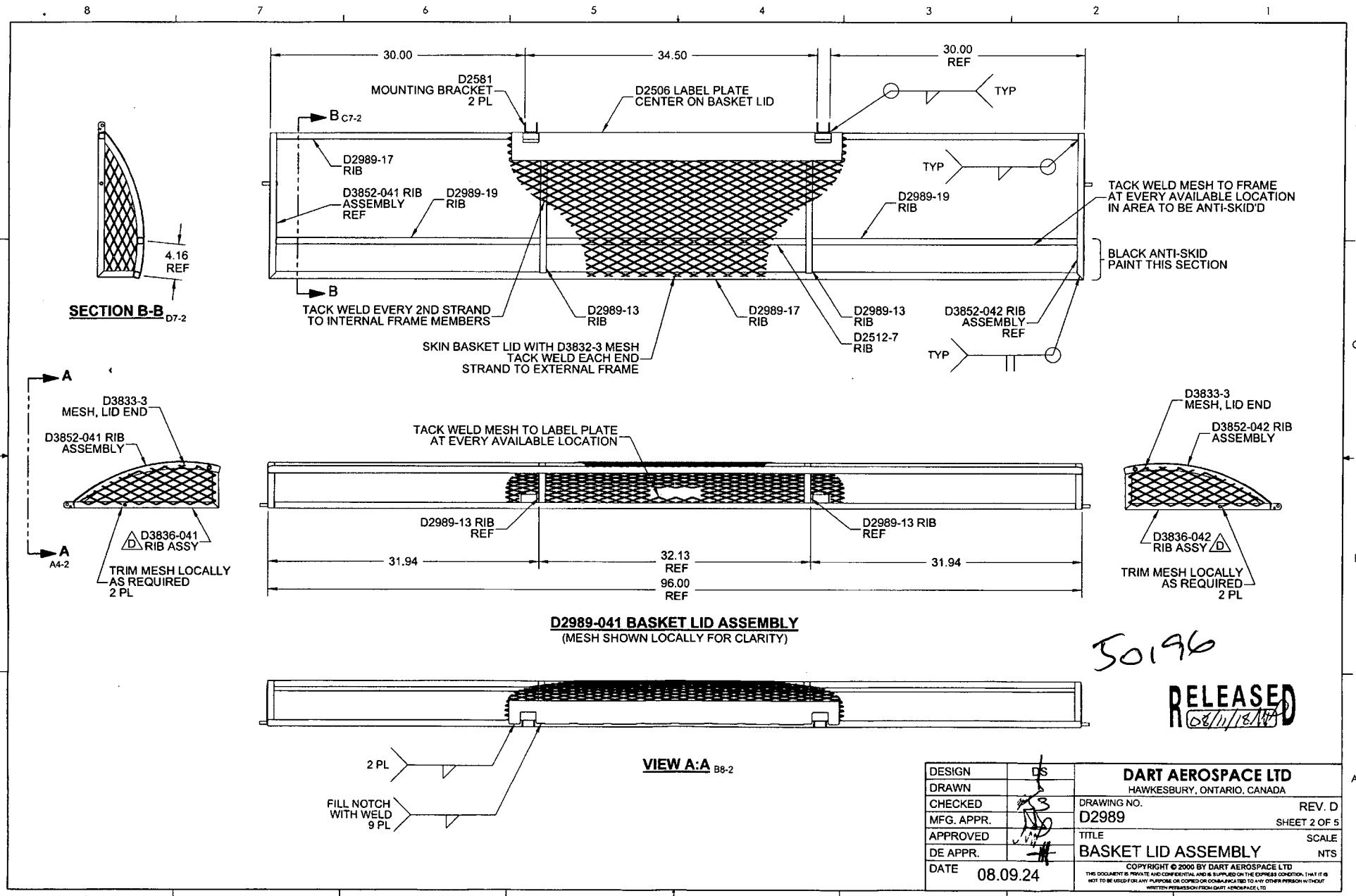
△

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21	1		D3838-041	RIB ASSY (BASKET LID, LH)
22	1		D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED  
08/11/18 MJD

W/O SOLICE

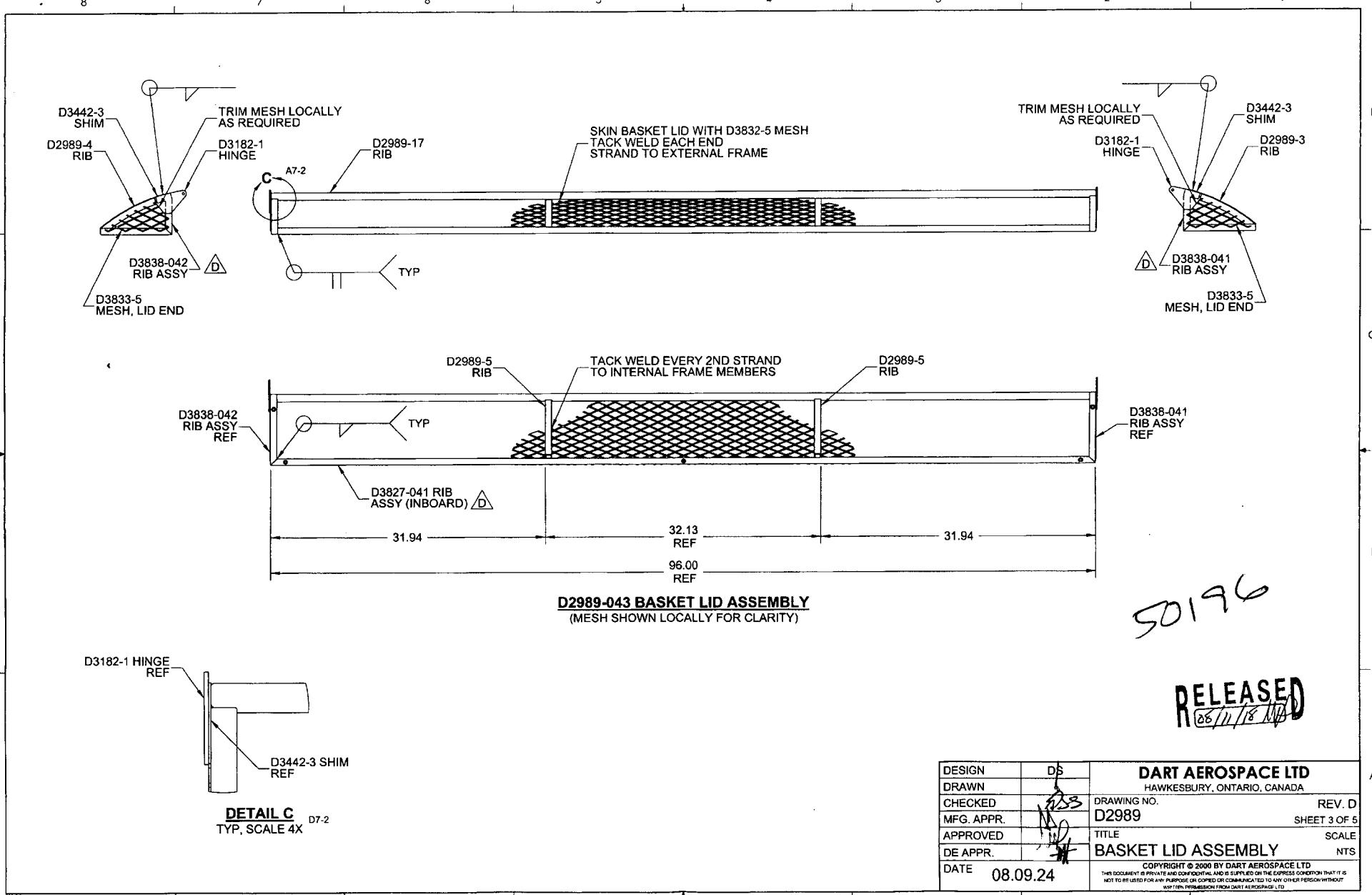
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/15; D3836-042 REPLACES D2989-10/15; D3838-041 REPLACES D2989-1/7; D3838-042 REPLACES D2989-2/7; D3852-04 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-1 (NOW INSTALLED ON D3836 DWG), D2989-9/10 (NOW ON D3836 DWG), D2989-1/2/7/15 (NOW ON D3838 DWG) AND D2989-1/12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.050 WALL, MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED	WJD	TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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50196

RELEASED  
08/11/18 MHD

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D	
MFG. APPR.		D2989	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<del><i>[Signature]</i></del>	BASKET LID ASSEMBLY	NTS	
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8 7 6 5 4 3 2 1

D

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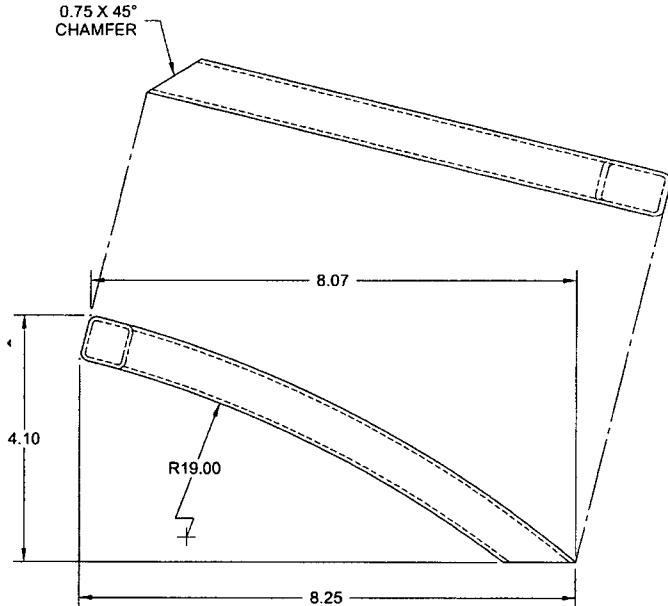
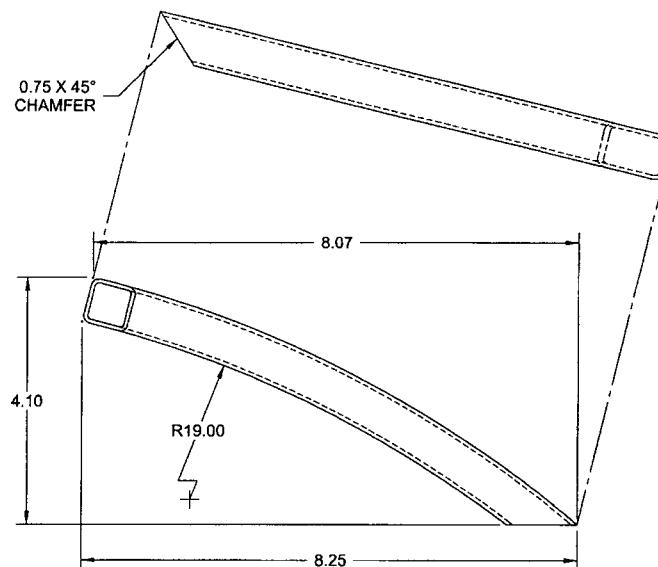
C

B

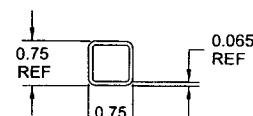
B

A

A

D2989-3 RIBD2989-4 RIB

50194

RELEASED  
08/11/18 MWDTYPICAL SECTION  
VIEW

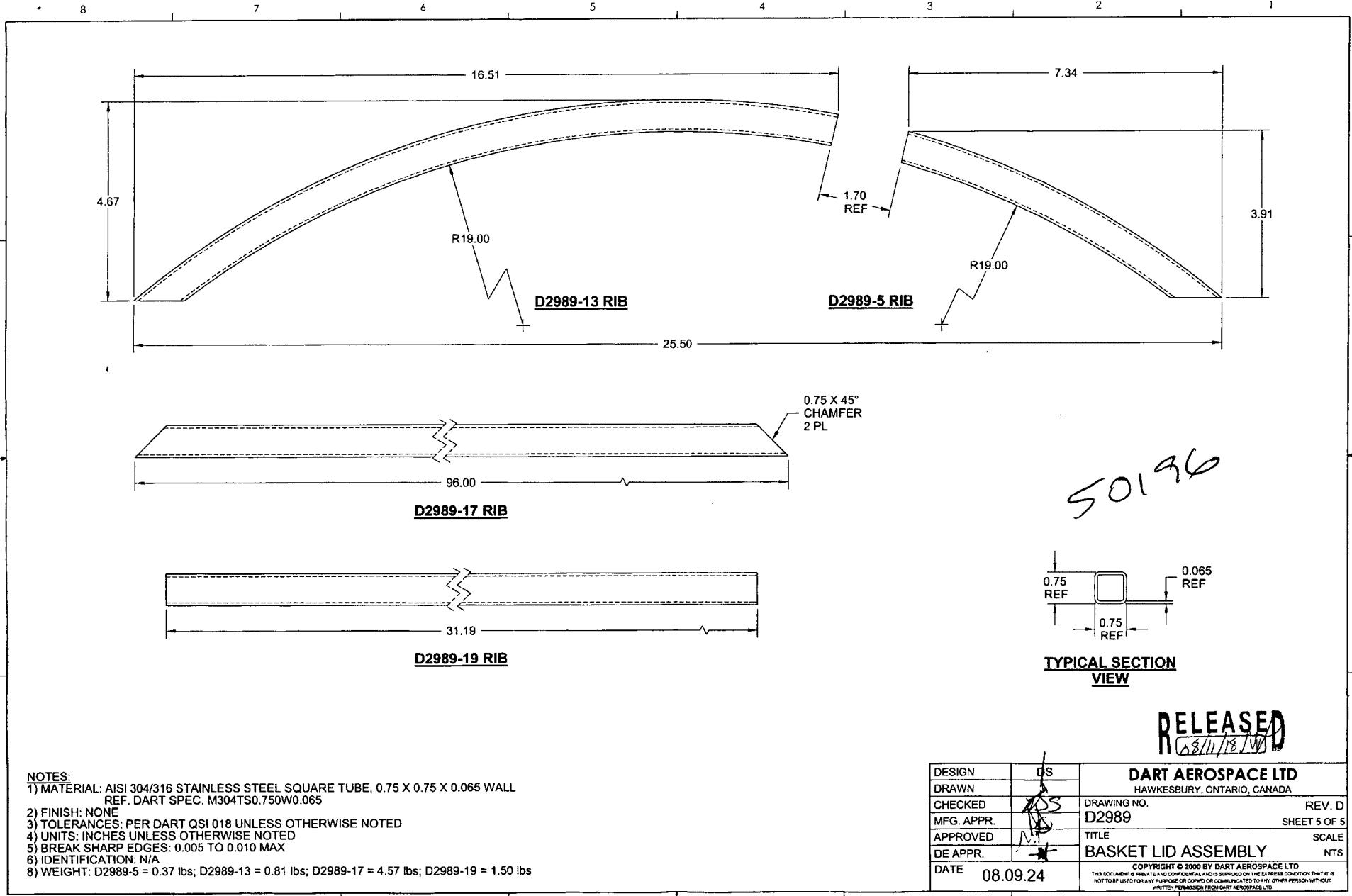
- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

8 7 6 5 4 3 2 1

DESIGN	DS	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. D
MFG. APPR.		DRAWING NO. D2989
APPROVED		REV. D OF 5
DE APPR.		TITLE
		SCALE
		NTS
DATE	08.09.24	BASKET LID ASSEMBLY

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DRAWN		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2989
MFG. APPR.		REV. D SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE BASKET LID ASSEMBLY
DE APPR.	<i>[Signature]</i>	SCALE NTS
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08/11/00